

CLAIMS

Sub B1

1. Method for coating container bodies internally with a coating material as they emerge in succession from a welding machine, characterized in that the coating material is fed from the welding machine end of a spray process and is sprayed inside the container body more or less uniformly onto the internal wall over its entire circumference, particularly by using a rotating element, and in that sprayed coating material is extracted from inside the container bodies <sup>2</sup> and is returned back toward ~~to be returned via the upstream in direction~~ to the welding machine.

2. Method according to claim 1, characterized in that the gap between successive container bodies is reduced in the region of the spray process.

3. Method according to claim 1 ~~or 2~~, characterized in that the <sup>powder</sup> coating material is sprayed inside the <sup>each</sup> container body from downstream of the extraction zone in the container body conveying direction.

4. Method according to claim 1 ~~or 2~~, characterized in that the <sup>powder</sup> coating material is sprayed inside the <sup>each</sup> container body from upstream of the extraction zone in the container body conveying direction.

5. ~~Apparatus for coating container bodies (6)~~

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internally with a coating material as they emerge in succession from a welding machine ~~(11)~~, characterized in that at least one feed line ~~(12)~~ for the coating material and at least one return line ~~(13)~~ for the coating material are provided through the welding machine, and in that a combined spray and suction head ~~(14)~~ is connected to the feed and return lines and is positioned so as to act on the interior of the container body over its entire circumference.

6. Apparatus according to claim 5, characterized in that the spray and suction head ~~(14)~~ has one or more spray orifices ~~(18)~~ arranged upstream of one or more extraction openings ~~(17)~~ in the container body conveying direction.

7. Apparatus according to claim 5, characterized in that the spray and suction head ~~(14)~~ has one or more spray orifices ~~(20)~~ arranged downstream of one or more extraction openings ~~(27)~~ in the <sup>container</sup> body conveying direction.

8. Apparatus according to ~~any one of claims 5 to 7~~, characterized in that a device is provided for reducing the gap between successive container bodies in the region of the spray and suction head, ~~in particular a body braking device~~.

9. Apparatus according to claim 5, characterized in that the spray head has a rotating element ~~(16, 26)~~ to give

a uniform distribution of the powder over the circumference  
of the container body.

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